

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000784**Date Inspected:** 02-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Wen Sheng & Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 77 & 89 Mock-Up**Summary of Items Observed:**

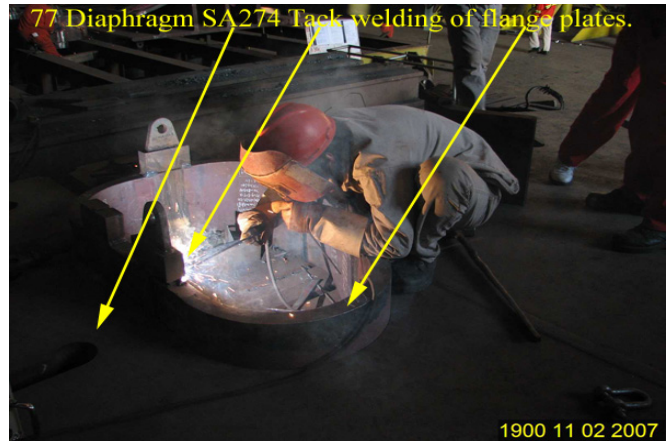
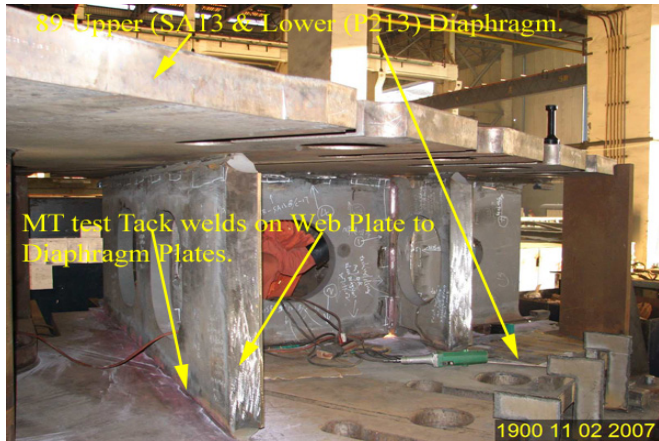
On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 77 Meter Mock-Up SA274. Tack welding of the flange plates was in progress. Welding being performed by Zhenhua Port Machinery Company (ZPMC) welder Yang Lei #040690 certified for Shielded Metal Arc Welding (SMAW) in the 3G position. The procedure used was WPS-B-P-2213-B-U3b and utilizing welding rods TL508 taken from a hot rod box. The welding parameters recorded by this QA Inspector were, Amps 154, Volts 26.0 and the Temperature 110c. The CWI present was Sha Zhi and the QC was Chen Tan.

Item-2 89 Meter Mock-Up Upper (SA13) and Lower (P213) Diaphragm to Web plate tack welding. A Magnetic Particle (MT) test was performed on selected areas of the lower diaphragm to web plate tack welding by this Caltrans QA Inspector and was found to be in compliance with the project specifications. The CWI present was Ye Yong Jun, (BV) Li Wen Sheng and the QC was Zhang Lei.

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Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer